

Date: Wednesday, 1/11/2006 4:29:32 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE SIDE LH (206 HI-SLOPE)
Job Number : 25472	
Estimate Number : 11001	
P.O. Number : N/A	Part Number : D26022
This Issue : 1/11/2006 S.O. No. : N/A	Drawing Number : D2602 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 25141	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/30/2006 Qty: 10 Um: Each
Checked & Approved By : SEE ABOVE DATE & USEC	
Comment : Est. E 04.02.25 Reformat KJ/RF	
Note: Issue with part number D2602-1	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 1.4146 sf(s)/Unit Total : 14.1456 sf(s)
2024-T3 .040 sheet
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040) Batch H 19059

ml 06/02/20 10

2.0	SHEAR	SHEAR
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Comment: SHEAR
Cut Blank per template DT8243

ml 06/02/20 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA145 and Dwg D2602
Stack of 10
Identify as D2602-2

ml 06/02/20 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/02/20 10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Ep 06/02/20 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 25472

Part Number: D26022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

DL 06/02/22

10

SB 06/02/24

10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-24 10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/02/26

10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-02-27 10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

use for 25446 w/o ml 06/07/27 10

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/27

Job Completion



u 06.02.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

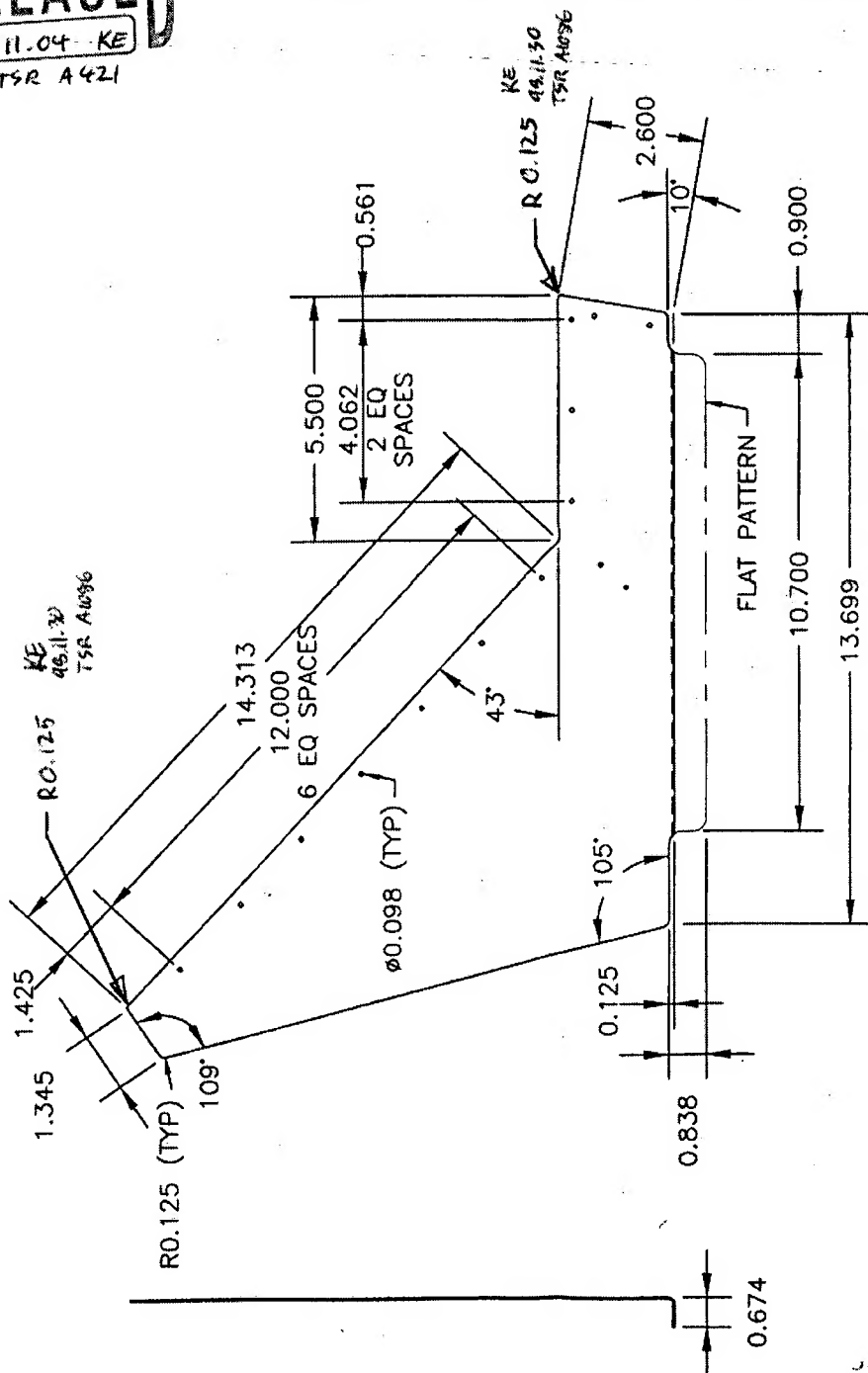
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



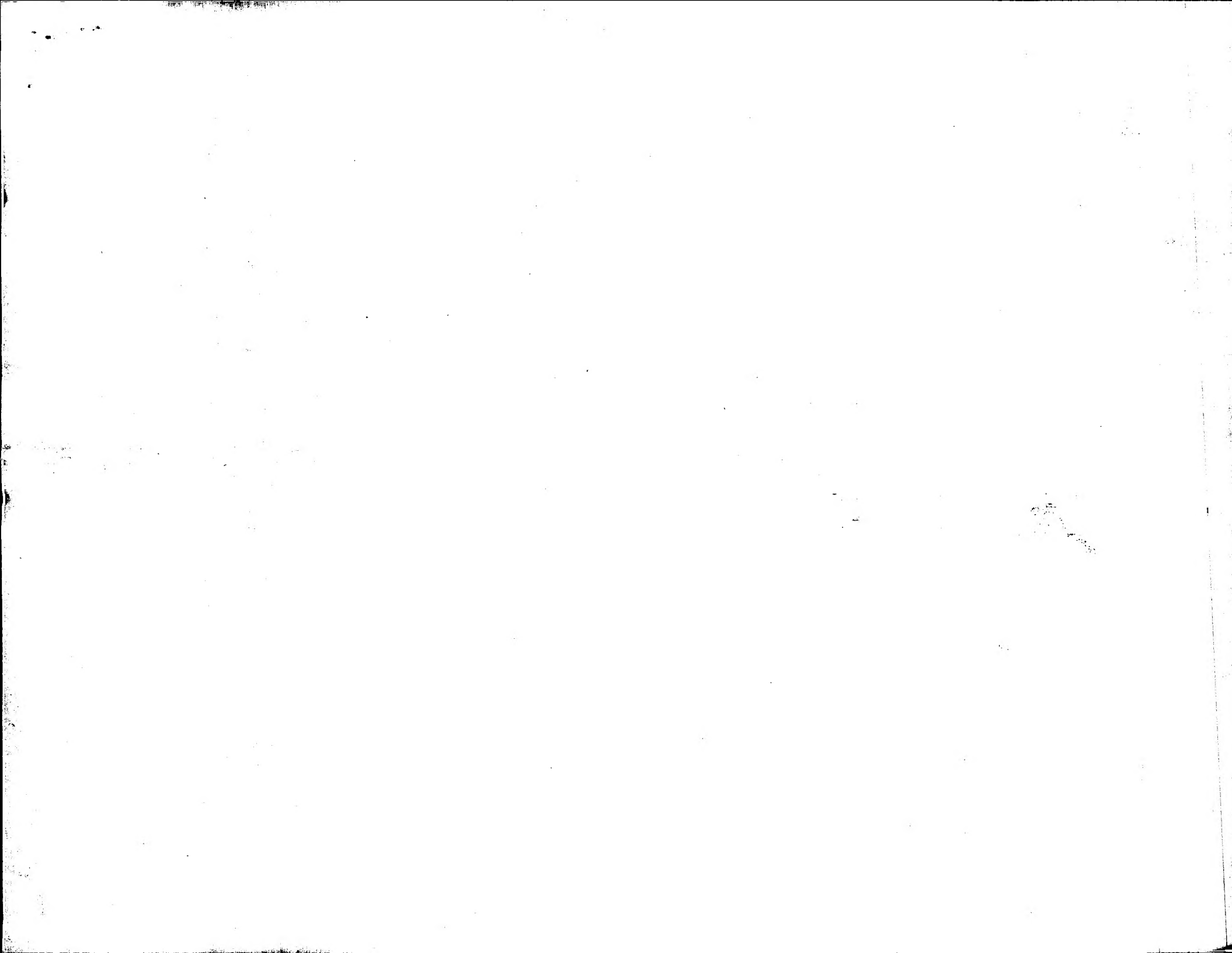
DESIGN <i>JS</i>	DRAWN BY BW	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED KE	APPROVED <i>JS</i>	DRAWING NO. D2602	REV. A SHEET 1 OF 1
DATE 97.10.22	TITLE CONSOLE SIDE		SCALE 1:4
A	97.10.22	D2602 WAS D206-547-21/ -22	
AI	<i>JS</i> 02.06.04	ADD FINISH	

RELEASED
97.11.04 - KE
TSR A421



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2602
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 4-1 A1
D2602-1 SHOWN
D2602-2 OPPOSITE

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	<i>mf</i>	Audited by:	<i>En</i>	Prototype Approval:	
Date:	<i>06/02/20</i>	Date:	<i>06/02/20</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

